

3392

Work Order ID 86634

86634

Page 1

Item ID: D4547-5

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Vertical Linkage Tube

Stop *NS2*

Start Date: 7/5/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: *UMK*Date: *2-07-06*

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4547

B

100

0.00

100

Doosan

Doosan Lathe

Memo

MILL/TURN AS PER DWG

DWG REV: _____

FOLIO REV: _____

DEBURR

Manual

0.00

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

*12-7-31**12-08-02**PTC*

W/O: 86634

WORK ORDER CHANGES

| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
|------|------|------------------|----|------|-----|-------------------------------------|--------------------------|
| | | | | | | | |
| | | | | | | | |

Part No: D2856-600

PAR #:

Fault Category: Machining

NCR: Yes No

DQA: AutDate: 12/08/13

Resolution:

Disposition: use as isQA: N/C Closed: SDDate: 12/08/14NCR: 12-11662

WORK ORDER NON-CONFORMANCE (NCR)

| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
|--------|------|---|---|---------------------------------|-----------------------|---------------------------|---|---|
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 120802 | 100 | DEPTH OF HOLE, 1.00" (2W C3-3) IS MACHINED TO 1.20". RC. PROCESS | <u>DAS</u> <u>22</u> <u>08</u> 1208-02 | ACCEPTABLE DEVIATION. | <u>SD</u> 08/02/12 | D.A 12/08/03 | <u>DAS</u> <u>22</u> <u>08</u> 1208-02 | <u>DAS</u> <u>16</u> <u>08</u> 1208/07 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 86634

Friday, July 06, 2012 11:45:19 AM

86634

Page 2

Item ID: D4547-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Vertical Linkage Tube

Stop

NS2

Start Date: 7/5/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

B.a 12/08/03

2

0

150

Identify as per dwg & Stock Location: **8241A** 0.00

150

Packaging

Memo

0.00

Packaging

2x

12-8-7.

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/8/07

MLT 12/08/07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Friday, July 06, 2012 11:45:17 AM

Page 1

Work Order ID: 86634

Parent Item: D4547-5

Parent Item Name: Vertical Linkage Tube

Start Date: 7/5/2012

Required Date: 7/19/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 12-01-10 JLM VERIFIED BY:DD
DWG REV.B DD VERF:EC IPP REV:B 12.06.12 AS PER

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M174R0.375 17-4 SS ROUND BAR .375" | | Purchased | No | | | 100 | f | 24.0000 | 2.9 | 6.1052632 | | | |

Location

Loc Qty

Loc Code

MAT030

24

121546

24

6.2 12-07-31

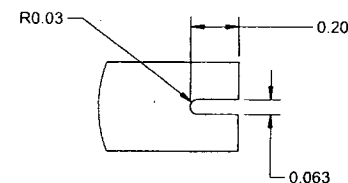
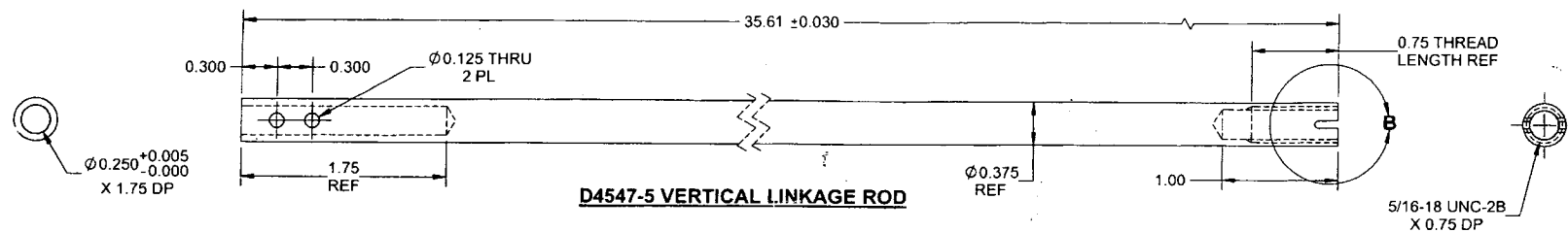
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: 17-4 PH / S17400 / TYPE 630 STAINLESS STEEL ROUND BAR
PER AMS 5643 / ASTM A564 (REF DART SPEC M17-4-R0.375)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.08 lbs

| | | | |
|------------|--------------------|--|--------------|
| DESIGN | RP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AP | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. D4547 | REV. B |
| MFG. APPR. | <i>[Signature]</i> | TITLE VERTICAL LINKAGE ASSY | SHEET 3 OF 3 |
| APPROVED | <i>[Signature]</i> | SCALE NTS | |
| DE APPR. | <i>[Signature]</i> | COPYRIGHT © 2012 BY DART AEROSPACE LTD | |
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RELEASED
R 2012-06-05

86634

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | | | | | | |

NOTE: Date & initial all entries

(continued)

244

1990

11

54

590